

Date: Monday, 27/04/2009 12:50:31 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HANDLE ASSEMBLY
Job Number	: 47512		
Estimate Number	: 10439		
P.O. Number	:	Part Number	: D3331041 FR
This Issue	: 27/04/2009 S.O. No. :	Drawing Number	: D3331 REV. C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: C
Previous Run	: 46746	Material	:
Written By	:	Due Date	: 30/04/2009
Checked & Approved By	: <u>JUD 09.04.27</u>	Qty:	<u>5</u> Um: Each
Comment	: Est: C 05.05.26 Added D3158-050 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1025TR0875W125	1025 Round tubing .875 x .125w



Comment: Qty.: 1.5000 f(s)/Unit Total: 6.0000 f(s)

1025 Round Steel Bar

Material: AISI 1010-1025 Ø0.875" tubing, 0.125" wall

(M1025TR0.875W.125)

Batch: B41075009-04-28 (5)

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- Cut handle to finish length as per Dwg D3331

2- Form as per Dwg D3331 using DT8760 crimping Jig

SAD 09-04-28 (5)

3.0	LATHE CONV.	CONVENTIONAL LATHE
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Comment: CONVENTIONAL LATHE

Turn as per Dwg D3331

Identify as D3331-1

ml 09/05/01 (5)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 09/05/01 (5)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 09/05/01 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 27/04/2009 12:50:31 PM
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Drawing Name: HANDLE ASSEMBLY

Job Number: 47512

Part Number: D3331041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

238032

3/16" Dowel Pin 1" long



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

3/16" Dowel Pin 1" long

Pick:

Qty	Part Number	Description
1	238-032	3/16"-1" long Dowel

Batch

M106162 = 5x SP 09.05.5

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Deburr

2- Drill dowel hole as per Dwg D3331

3- Insert and Weld dowel as per Dwg D3331

Qty	Part Number	Description
A/R	N/A	Steel Rod

Batch

M108350 SP 09.05.5

(5x)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

DE 09-05-05

(5x)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME:

8:55

OVEN TEMPERATURE:

320°

FINISH TIME:

9:25

FX 09/05/06

(5)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

09-05-06

(5)

11.0

GP78R

Black Vinyl Grid



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Black Vinyl Grid

Pick:

Qty	Part Number	Description
1	GP-78R	Black Vinyl Grid

Batch

M1110 76

EP 09/05/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE ASSEMBLY

Job Number: 47512

Part Number: D3331041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D3158

Heat Shrink Tubing



Comment: Qty.: 0.4166 f(s)/Unit Total: 1.6664 f(s)

Heat Shrink

Pick:

Qty Part Number

Description

Batch

5" D3158

Heat Shrink

B24615

09/05/06

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble as per Dwg D3331

Identify as D3331-041

09/05/06 (5)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/05/06

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Carl

09/05/07

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/07

Job Completion



mk
09-05-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

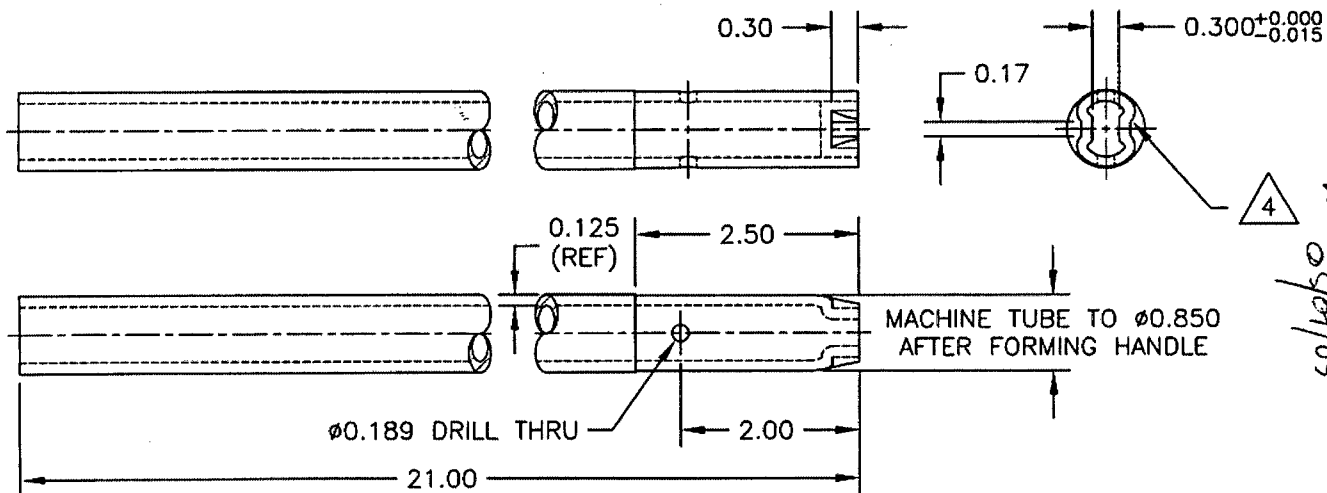
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

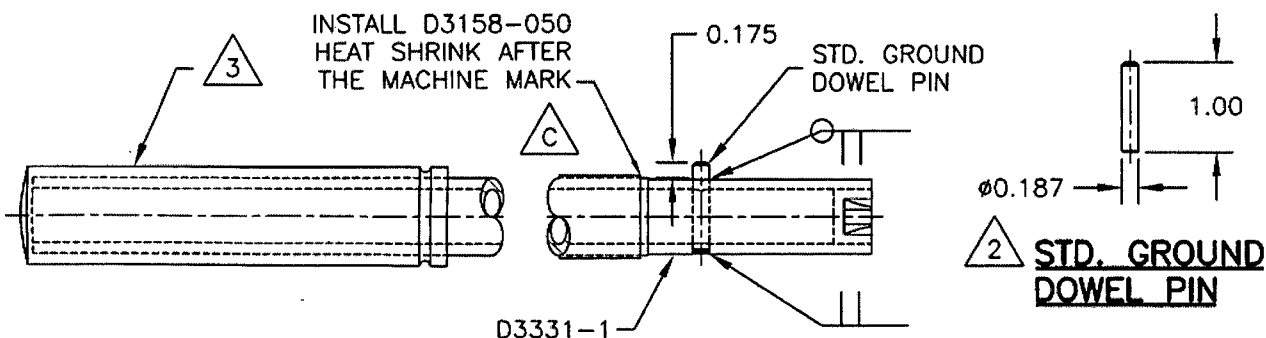
NOTE: Date & initial all entries

DART

RELEASED
05/01/05



D3331-1 HANDLE



D3331-041 HANDLE ASS'Y

NOTES:

- 1) MATERIAL: 1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR0.875W.125)
- 2) STD. GROUND DOWEL PIN, $\phi 3/16$ " x 1.00" LONG
POSSIBLE SUPPLIER: SPAENAU, P/N 238-032
- 3) STD. BLACK VINYL GRIP, 7/8" I.D. x 4 3/4" LONG
POSSIBLE SUPPLIER: REID TOOL SUPPLY CO., P/N GP-78R
- 4) FORM USING TOOLING DT8760
- 5) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK CENTER

NO

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. C
05.05.20	D3331	SHEET 1 OF 1
	TITLE	SCALE
	HANDLE WELDMENT	1:2
A	04.11.29	NEW ISSUE
B	05.02.18	LENGTH 21.00 WAS 18.00
C	05.05.20	ADD D3158-050